

Date: Monday, 02/03/2009 9:02:01 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PILOT/CO-PILOT STEP, LH (FOLDING)
Job Number : 46118	
Estimate Number : 10813	
P.O. Number :	Part Number : D412630031
This Issue : 02/03/2009 S.O. No. :	Drawing Number : IIN D412-630
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : <i>1m 09/03/02</i>
Previous Run : 46117	Material :
Written By :	Due Date : 16/03/2009 Qty: 4 Um: Each
Checked & Approved By : <i>JUD 09.03.02</i>	
Comment :	
EST. REV. A 05.11.21 NEW ISSUE EC	
EST. REV. B 05.12.19 updated pick list EC	
EST. REV. C 07.11.12 ecn 1019,no chg EC verified by	
DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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for JUD 09/03/16



Comment: DOCUMENT CONTROL

Photocopy D412-630 bluefile & type labels per PPP412-630-031 *CHG002**CHG001**09/03/02*

2.0	D3463041	Step Weldment Assembly
-----	----------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-041	Step weldment	<i>4625</i>

09/03/1704

3.0	D3443043	Strut Weldment Assembly
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-043	Strut ass'y	<i>B46129</i>

09/03/2004

4.0	D3443041	Strut Weldment Assembly
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-041	Strut ass'y	<i>B46127</i>

09/03/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Part Number: D412630031

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D34439	Pin
-----	--------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3443-9	Pin	

Handwritten: 8809/03/16 (x4)
~~133~~ B30228x7
B346131 x1

6.0	AN4CH3	SS Bolt
-----	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN4CH3	BOLT	
A/R	MS20995c41	Lockwire	

Handwritten: M110665
M1101537

Handwritten: 8809/03/16 (x4)

7.0	AN4C14	BOLT
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN4C14	BOLT	

Handwritten: M1103240 x1
M110552 x3

Handwritten: 8809/03/16 (x4)

8.0	D34547	Bushing
-----	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3454-7	Bushing	

Handwritten: B344792 x7
B344589 x1

Handwritten: 8809/03/16 (x4)

9.0	AN3104	NUT
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN310-4	Nut	

Handwritten: M1107139

Handwritten: 8809/03/16 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 46118

Part Number: D412630031

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

MS24665227

COTTER PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-227	COTTER PIN	M169174

SS 09/03/16 (x4)

11.0

D34551

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3455-1	Spacer	B44602x5 B41844 v3

SS 09/03/16 (x4)

12.0

D34651

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3465-1	Washer	41692

SS 09/03/16 (x4)

13.0

AN3107

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN310-7	Nut	M163286

SS 09/03/16 (x4)

14.0

MS24665302

Cotter Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-302	COTTER PIN	M166763

SS 09/03/16 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 46118

Part Number: D412630031

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.17

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

8/509/03/23 (4)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

****ensure tension to retract step is 11 to 18 lbs ****

509/03/23 (x4 LH)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

18.0

D34541

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

5 (x4)

Qty

Part Number

Description

Batch

1

D3454-1

Bushing

B46135 x2
B33730 x2

8/509/03/17 (x4)

19.0

D34543

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

5 (x4)

Qty

Part Number

Description

Batch

2

D3454-3

Bushing

4932

8/509/03/17 (x4)

20.0

D34545

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

5 (x4)

Qty

Part Number

Description

Batch

2

D3454-5

Bushing

40933

8/509/03/17 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 46118

Part Number: D412630031

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D34551

Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total : ~~24.0000~~ Each(s)

Pick:

Mon/03/02
84

Qty Part Number

Description

Batch

D3455-1

Spacer

B414602 x12

B46133 x4

SS 09/03/17 (x4)

22.0

D34553

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

D3455-3

Spacer

B30227

SS 09/03/17 (x4)

23.0

D3462041

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D3462-041

Bracket ass'y

B4448612

B45059 x2

SS 09/05/17 (x4)

24.0

AN3104

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

AN310-4

Nut

M111060

SS 09/03/17 (x4)

25.0

AN3105

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

AN310-5

Nut

M110552

SS 09/03/17 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 46118

Part Number: D412630031

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN3C5A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

3

AN3-C5A

Bolt

M110985

8809/03/17 (x4)

27.0

AN44C12

eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

AN44-C12

Eyebolt

M110342

8809/03/17 (x4)

28.0

AN4C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

AN4C15

BOLT

M110155

8809/03/17 (x4)

29.0

AN5C11

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

AN5C11

BOLT

M1103248

8809/03/17 (x4)

30.0

AN5C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

AN5C15

BOLT

M110155

8809/03/17 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 46118

Part Number: D412630031

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

AN960C10

WASHER



Comment: Qty.: 7.0000 EACH(s)/Unit Total : 28.0000 EACH(s)

Pick:

Qty

Part Number

Description

Batch

7

AN960C10

Washer

M169148

32.0

AN960C516

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

AN960C516

Washer

M102842

33.0

MS210433

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

3

MS21043-3

Nut

M110153

34.0

MS24665227

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

MS24665-227

COTTER PIN

M109174

35.0

MS24665229

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

MS24665-229

COTTER PIN

M109174

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 46118

Part Number: D412630031

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

NAS1515H5

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

NAS1515H5

Washer

M109430

09/03/17 (X4)

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

09/03/03 (X4)

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-031

Location:

PPP Rev:

31
P

9/3/03

(X4)

SP

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/24 (X4)

Job Completion



MF
09-03-24

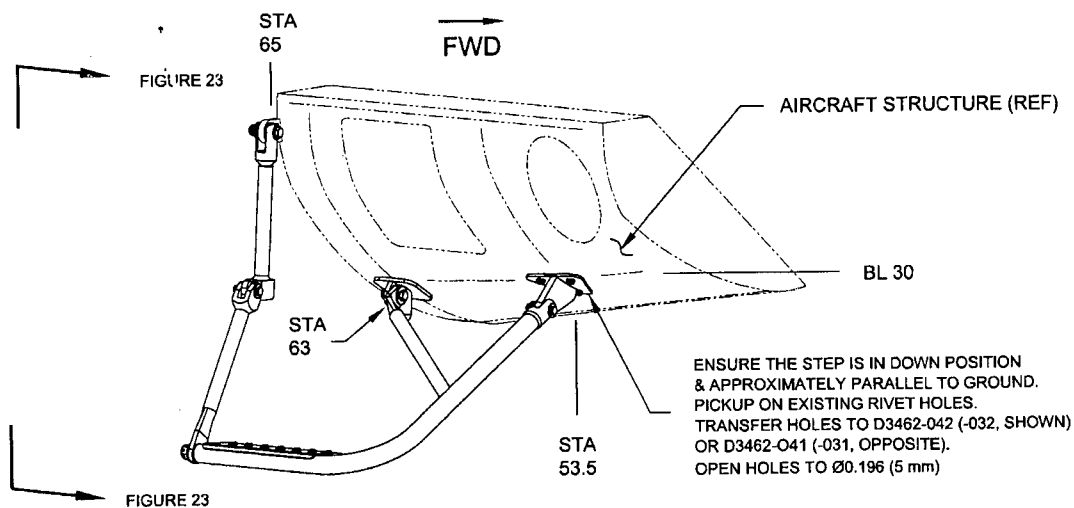
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

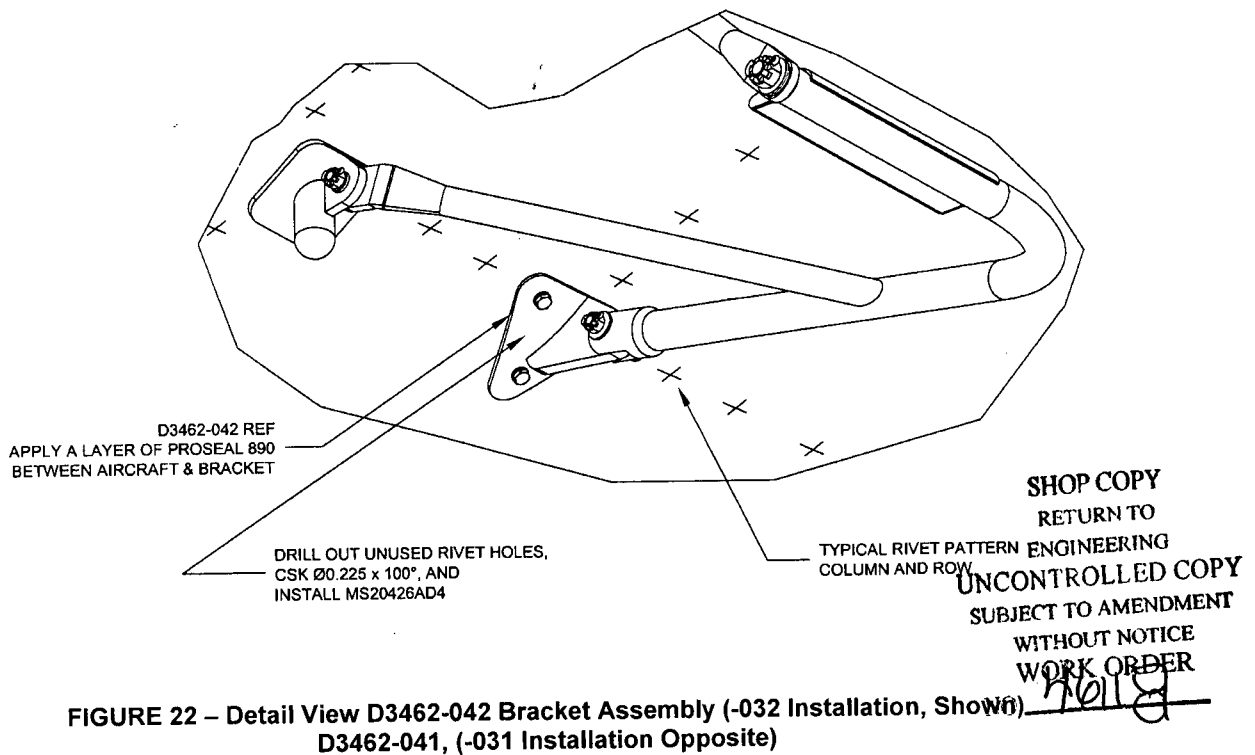
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D412-630-031/-032 Pilot/Co-Pilot Folding-Step Installation

**FIGURE 21 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown),
D412-630-031 LH (Opposite)**



**FIGURE 22 – Detail View D3462-042 Bracket Assembly (-032 Installation, Shown)
D3462-041, (-031 Installation Opposite)**

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Revision: **M**
Date: 08.12.12

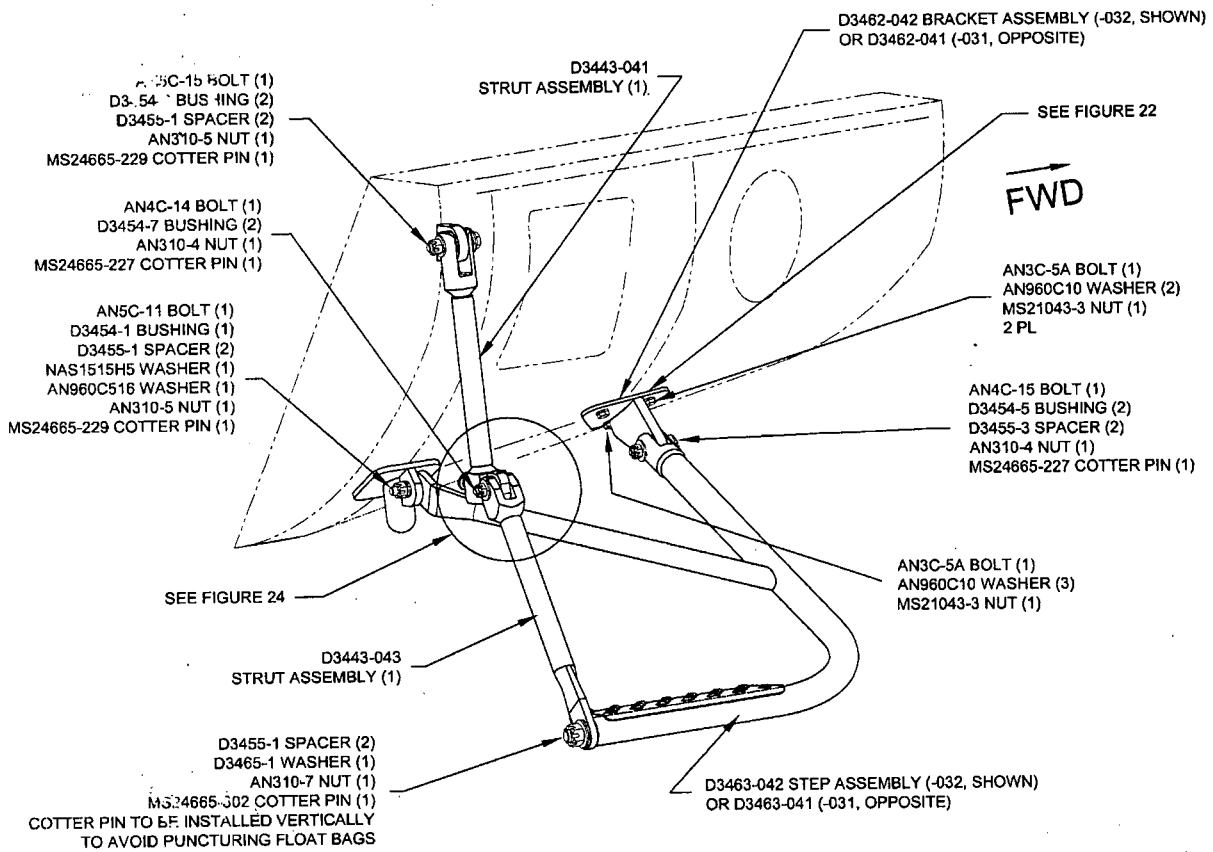


FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

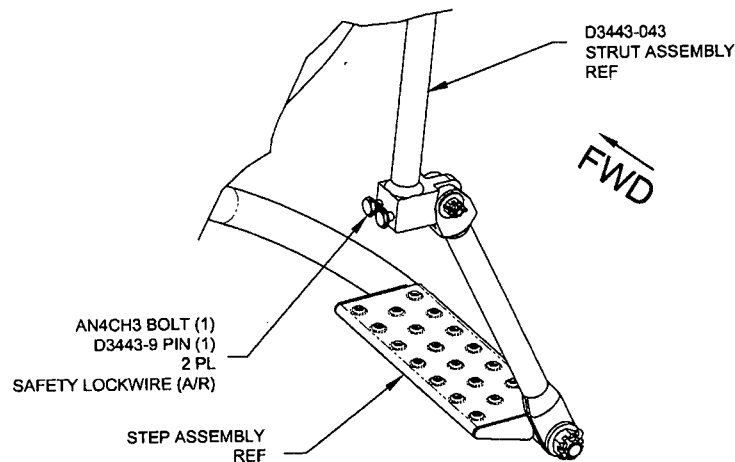


FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

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Revision: M
Date: 08.12.12

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NO. 46118